

IN THE CLAIMS

Please amend the claims as follows:

Claim 1 (Currently Amended): A method of manufacturing a product, comprising:  
filling a resin containing a foaming agent into a mold cavity by injection within a time period from a time point just before completion of mold clamping to a time point after the completion of mold clamping;

allowing the resin filled in the mold cavity to form a skin layer over a surface of the resin;

retracting a movable mold to provide a predetermined cavity clearance between the movable mold and a stationary mold to cause the foaming agent to foam; and

cooling the resin filled in the mold cavity to form a foam-molded product having a tight skin layer surface and an inside portion in a foamed state,

wherein an amount of the resin to be filled into the mold cavity at the time point just before the completion of the mold clamping is between 50% and 80% of the total amount of the resin to be filled in the mold cavity.

Claim 2 (Canceled).

Claim 3 (Currently Amended): The method according to claim 1 ~~or~~ 2, wherein the filling of the resin at the time point just before the completion of the mold clamping starts within a time period between five seconds before the completion of the mold clamping and the completion of the mold clamping.

Claim 4 (Currently Amended): The method according to claim 1 ~~or~~ 2, wherein the resin is injected into the mold cavity at an injection speed of between 5 and 20 cm/sec.

Claim 5 (Currently Amended): The method according claim 1 ~~or~~ 2, wherein a time period from starting of the filling of the resin into the mold cavity until the foaming agent

Application No. 10/087,828

Reply to Office Action of June 25, 2004

contained in an inner portion of the resin filled in the mold cavity starts foaming is between 3 and 10 seconds.

Claim 6 (Currently Amended): The method according to claim 1 ~~or~~ 2, wherein a mold clamping pressure during the filling the resin into the mold cavity is between 20 kg/cm<sup>2</sup> and 100 kg/cm<sup>2</sup>, and a mold clamping pressure during the allowing the resin to form the skin layer is between 20 kg/cm<sup>2</sup> and 80 kg/cm<sup>2</sup>.